

Work Order ID 82746

April-05-12 12:58:24 PM

82746

Page 1

Item ID: D3529-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw

Stop

NS2

Start Date: 05/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3529	Rev A								

110

0.00

110

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3529-1BLANK

OHM W 1" B/k-

*(12)
Jm / IB
12-4-9*

12

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining2-Machine as per Folio FA645 and Dwg D35293-Debur

*PO/B 12/04/23
SL*

12

130

0.00

130

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*PO/B 12/04/23
SL*

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 82746***82746***

Page 2

Item ID: D3529-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 05/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

*OK 12/04/24**12**0*

150

Identify as per dwg & Stock Location: *PPP*

0.00

150

Packaging

Memo

0.00

Packaging

*82744**12**12/04/24 JB*

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*12/4/25 JB**12/04/25*

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Picklist Print

April-05-12 12:58:29 PM

Page 1

Work Order ID: 82746

82746

Parent Item: D3529-1

D3529-1

Parent Item Name: Bearpaw

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-06-28 JLM

IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	396.7000	1.265	15.97895			

MUHMWB10

**

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

35.19999474

120401

32.1999947

120972

3

MAT019

1.5

118814

1.5

ST052

360

121277

40

121278

320

12

121278

5m/1B

12-4-9

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DART AEROSPACE LTD		Work Order:	82746
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.502	✓		PHD-01	VERN
B	0.07 x 45°	+/-0.030 x 0.5°	0.053	✓		"	"
C	R0.25	+/-0.030	0.250	✓		Rad gauge	
D	0.250	+/-0.010	0.256	✓		H. G.	
E	0.625	+/-0.010	0.623	✓		PHD-01	VERN
F	0.950	+/-0.010	0.946	✓		"	"
G	1.63	+/-0.030	1.618	✓		"	"
H	12.14	+/-0.030	12.14	✓		PHD-11	M. TAPE
I							
J	5.70	+/-0.030	5.70	✓		"	"
K	0.375	+/-0.010	0.378	✓		PHD-01	VERN
L	0.525	+/-0.010	0.532	✓		H. G.	
M	0.13 x 45°	+/-0.030 x 0.5°	0.118	✓		PHD-01	VERN
N	R0.50	+/-0.030	0.500	✓		Rad gauge	
O	12.76	+/-0.030	12.76	✓		PHD-11	M. TAPE
P	3.38	+/-0.030	3.371	✓		PHD-01	VERN
Q	3.75	+/-0.030	3.749	✓		"	"
R	5.187	+/-0.010	5.185	✓		"	"
S	5.25	+/-0.030	5.249	✓		"	"
T	7.13	+/-0.030	7.122	✓		H. G.	
U	Ø0.260	+0.006/-0.001	0.260	✓		PIN gauge	
V	0.30	+/-0.030	0.305	✓		PHD-09	
W	0.93	+/-0.030	0.932	✓		PHD-01	VERN
X	1.30	+/-0.030	1.30	✓		"	"

Measured by: <i>PD/BA</i>	Audited by: <i>amf</i>	Prototype Approval:	N/A
Date: 12/04/23	Date: 12/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

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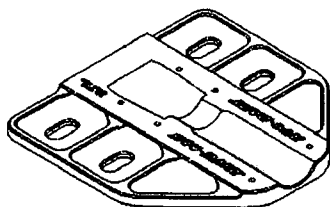
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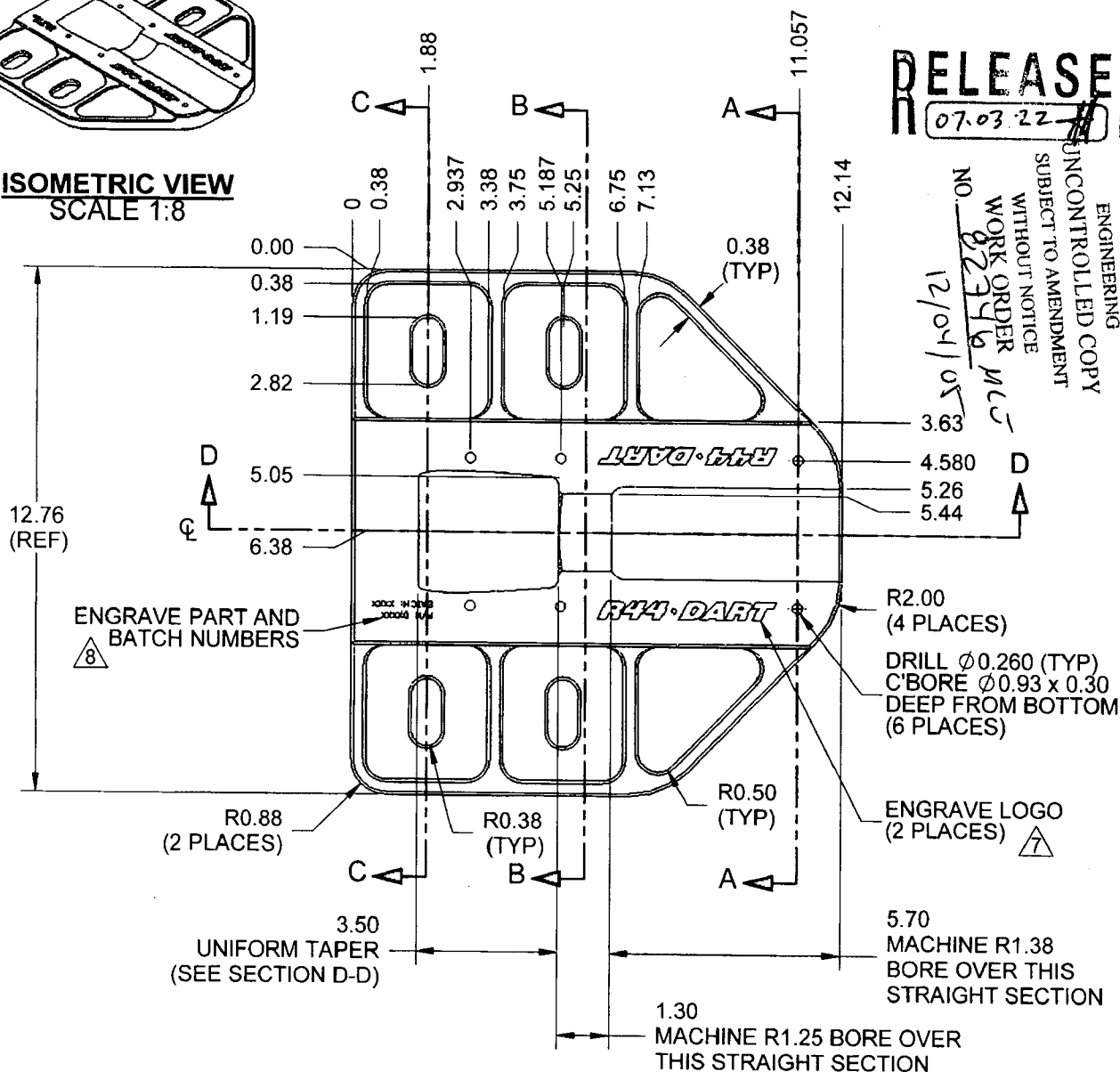
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04	TITLE R44 BEARPAW		SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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Dart Aerospace Ltd

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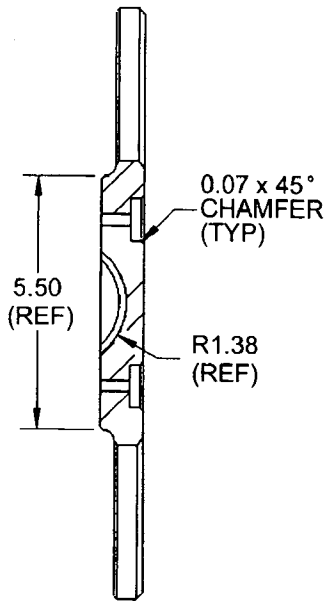
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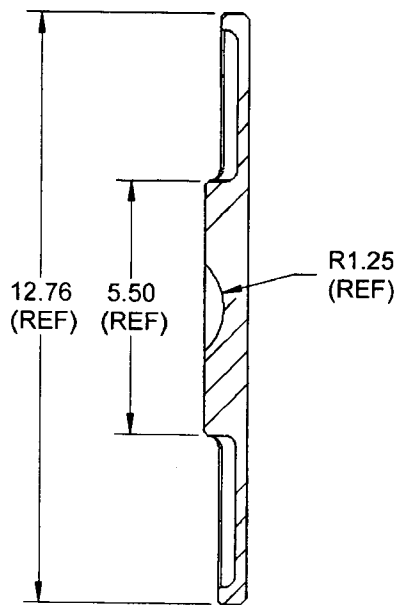


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A
DATE 07.01.04		TITLE R44 BEARPAW	SHEET 2 OF 2
			SCALE 1:4

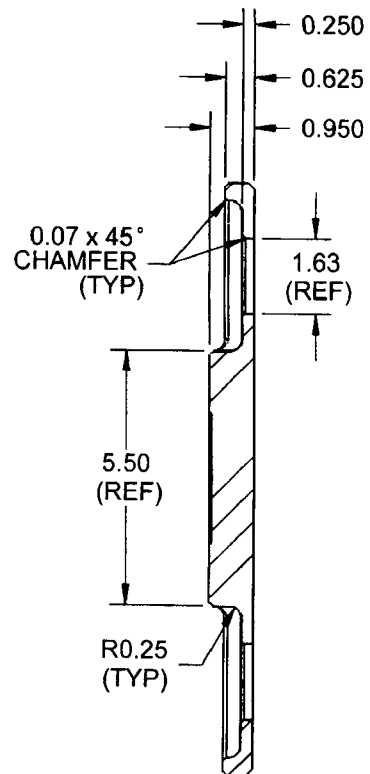
RELEASED
07.03.22



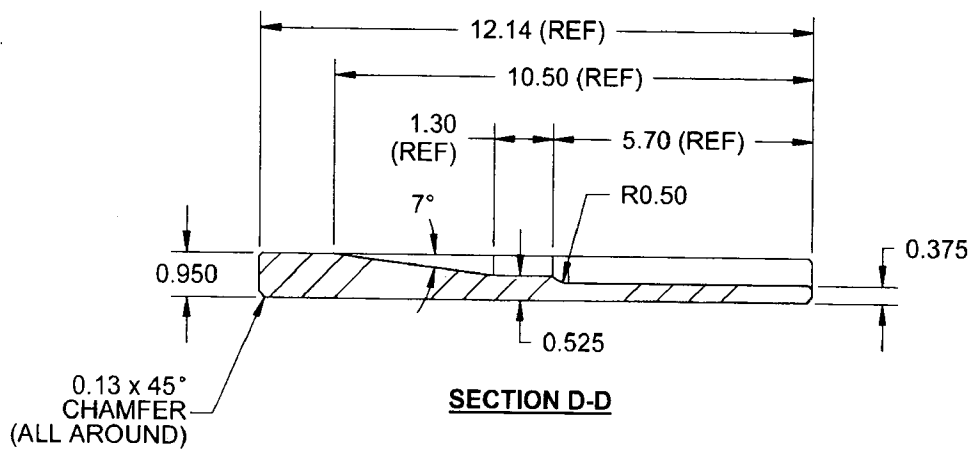
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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